

Work Order ID 116040

116040

Page 1

Item ID: D412-760-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cabin Floor Protector

Stop

NS2

Start Date: 4/04/14

Start Qty: 3.00

3

Cust Item ID:

Required Date: 4/04/14

Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

MLJ

Date: 14-08-18

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D412-760

G

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-760-011 CHG002

MLJ

14-08-18

3

3

DAS

38

9-89

14-8-22

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS

06

9-89

AUG 18 2014

DAS

28

9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

3

DAS

38

9-89

14-8-22

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 116040

116040

Page 2

August-18-14 8:12:14 AM

Item ID: D412-760-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cabin Floor Protector

Start Date: 4/04/14 Start Qty: 3.00

3

Cust Item ID:

Required Date: 4/04/14 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-760-011

Location: 040

PPP Rev: _____

0.00

0.00



AUG 02 2013

06
9-89

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

MLJ 1409-02

MLJ 1409-02

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

August-18-14 8:12:17 AM

Page 1

Work Order ID: 116040

116040

Parent Item: D412-760-011

D412-760-011

Parent Item Name: Cabin Floor Protector

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP rev A 07.07.05 new issue EC
IPP Rev:B 08-08-20 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3574-1		Manufactured	No			110	Each	0.0000	1	3			
D3574-1	DAS 38 9-89								**	2115573		DAS 38 9-89	DAS 38 9-89
Cabin Floor Protector													
D3574-2		Manufactured	No			110	Each	3.0000	1	3			
D3574-2	DAS 38 9-89								**	115850		DAS 06 9-89	DAS 28 9-89
Cabin Floor Protector													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		3							
				115850		3							
D3575-1		Manufactured	No			110	Each	1.0000	1	3			
D3575-1	DAS 38 9-89								**	119383		DAS 06 9-89	DAS 28 9-89
Cargo Floor Protector													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST201B		1							
				115651		1							
D3575-2		Manufactured	No			110	Each	0.0000	1	3			
D3575-2	DAS 38 9-89								**	115717		DAS 06 9-89	DAS 28 9-89
Cargo Floor Protector													
D3580-1		Manufactured	No			110	Each	130.0000	6	18			
D3580-1	DAS 38 9-89								**			DAS 06 9-89	DAS 28 9-89
Joggle Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST050		130							
				112450		4							
				113160		20							
				121071		100							
				98999		6							

DAS
38
9-89

14-9-2

DAS
28
9-89

4
14

Picklist Print

August-18-14 8:12:17 AM

Page 2

Work Order ID: 116040

116040

Parent Item: D412-760-011

D412-760-011

Parent Item Name: Cabin Floor Protector

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 3.00

Required Qty: 3.00

D3628-1

Manufactured No

110

Each

564.0000

14

42

D3628-1

DAS

**

DAS

Cupped Washer

38

06

9-89

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

FG

10

83587

10

ST053

554

116783

500

96822

54

42

D3628-3

Manufactured No

110

Each

379.0000

6

18

D3628-3

DAS

**

DAS

Cupped Washer

38

06

9-89

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

ST053

379

68213

3

96308

376

14

MS24694-S100

Purchased No

110

Each

97.0000

6

18

MS24694-S100

DAS

**

DAS

Flat Head Screw

38

06

9-89

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

ST292

97

125535

97

18

MS24694-S54

Purchased No

110

Each

198.0000

14

42

MS24694-S54

DAS

**

SCREW

38

DAS

9-89

06

Location

Loc Qty

Loc Code

ST293

198

125535

98

m129706

100

42

9-89

DAS

28

9-89

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Shop Packet Print

Page 2

Picklist Print

Page 3

August-18-14 8:12:18 AM

Work Order ID: 116040

116040

Parent Item: D412-760-011

D412-760-011

Parent Item Name: Cabin Floor Protector

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0363J

Purchased

No

110

Each

2,161.000

28

84

NAS1149D0363.J

Washer

Location

Loc Qty

Loc Code

GA

23

124392

23

ST276

5

m123441

5

ST510a

2133

m128429

2133

NAS1149D0463J

Purchased

No

110

Each

6,572.000

12

36

NAS1149D0463.J

WASHER

Location

Loc Qty

Loc Code

CA

485

M129682

485

ST277

6087

16941

8

M126221

20

M127813

6

M127904

127

M128591

44

M128995

1500

M129390

4382

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Part Number	Description
X					D412-760-011	CABIN FLOOR PROTECTOR KIT
	X				D412-760-013	CABIN FLOOR PROTECTOR KIT
		X			D412-760-015	CABIN FLOOR PROTECTOR KIT
			X		D412-760-017	CABIN FLOOR PROTECTOR KIT
				X	D412-760-019	CABIN FLOOR PROTECTOR KIT
1					D3574-1	CABIN FLOOR PROTECTOR
1					D3574-2	CABIN FLOOR PROTECTOR
	1				D3574-3	CABIN FLOOR PROTECTOR
	1				D3574-4	CABIN FLOOR PROTECTOR
		1			D3574-5	CABIN FLOOR PROTECTOR
		1			D3574-6	CABIN FLOOR PROTECTOR
1					D3575-1	CABIN FLOOR PROTECTOR
1					D3575-2	CABIN FLOOR PROTECTOR
	1				D3575-3	CABIN FLOOR PROTECTOR
	1				D3575-4	CABIN FLOOR PROTECTOR
		1			D3575-5	CABIN FLOOR PROTECTOR
		1			D3575-6	CABIN FLOOR PROTECTOR
6	4	6	6	6	D3580-1	JOGGLE BRACKET
			1		D3788-1	CABIN FLOOR PROTECTOR
			1		D3788-2	CABIN FLOOR PROTECTOR
			1		D3788-3	CABIN FLOOR PROTECTOR
			1		D3788-4	CABIN FLOOR PROTECTOR
14	40	14	14	10	D3628-1	CUPPED WASHER
6	8	6	6		D3628-3	CUPPED WASHER
				1	D4122-1	FLOOR PROTECTOR, FORWARD
				1	D4122-3	FLOOR PROTECTOR, AFT
28		28	28		NAS1149D0363J	WASHER (AN960JD10)
12		12	12		NAS1149D0463J	WASHER (AN960JD416)
14		14	14		MS24694S54	SCREW
6		6	6		MS24694S100	SCREW